

Work Order ID 58840

Wednesday, May 19, 2010 1:37:28 PM



Page 1

Item ID:	D3702-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Fwd Doubler				Stop	
Start Date:	5/19/2010	Start Qty:	2.00			
Required Date:	5/26/2010	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:		Date:	10-5-19	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3702	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3702 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-								
6061 - 080	Deburr if necessary								

10-5-07

(2)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

10-5-07

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8/10/12

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3702-1

Accept



Setup Start



Revision ID:

Item Name: Fwd Doubler

Stop



Start Date: 5/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr if necessary								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

*ulv S**2 Bl 10-5-31*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Item ID: D3702-1 Accept  Setup Start 
Revision ID:
Item Name: Fwd Doubler Stop 
Start Date: 5/19/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 5/26/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
									
QC	Memo	0.00	10/05/31			X2	0		
Quality Control									

170	Identify as per dwg & Stock Location: <u>83</u>	0.00							
									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

10-5-31 5/30
10/06/01
R/10-6-01
(2)

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:37:33 PM

Page 1
T

Work Order ID: 58840



Parent Item: D3702-1



Parent Item Name: Fwd Doubler

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A 08-01-30 new issue DD verified by:ec

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	161.2419	0.68	2.		



6061-T6 .080 Sheet



1310-5-07

Location

Loc Qty

Loc Code

MAT21

161.24193

113438

2.7512

114351

158.49073

114351

2

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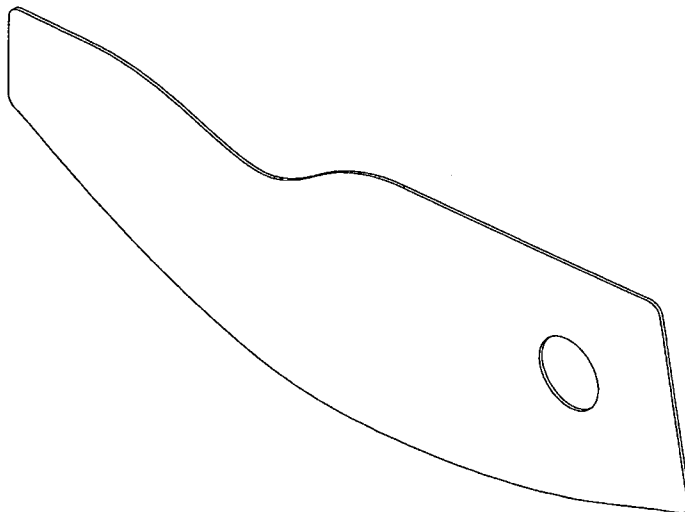
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D3702-1 FORWARD DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3702-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3702-1 = 0.39 lbs
- 8) MANUFACTURE PART FROM "D3702-1.DXF" FILE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58840
10-5-19

RELEASED
07/24/2010

B	Ø1.375 WAS Ø1.25 (ZN B5-2) REASON: HOLE ENLARGED FOR INSTALLATION OF GROMMET	MB	08.07.10
A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.10		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B SHEET 1 OF 2	
DRAWING NO. D3702		TITLE FORWARD DOUBLER	
SCALE NTS		NTS	
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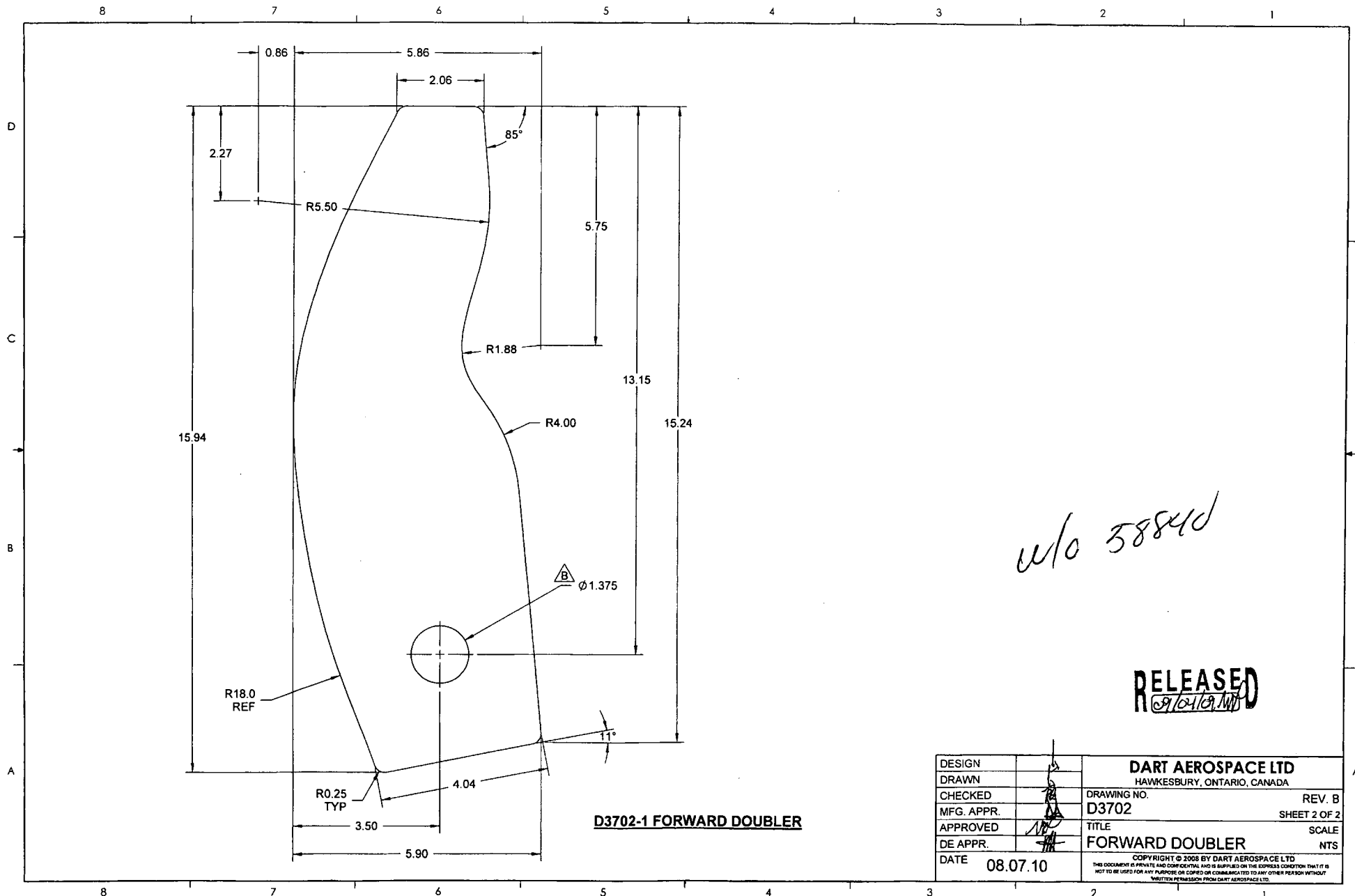
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w/o 3884d

RELEASED
9/10/10 MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3702	REV. B
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		FORWARD DOUBLER	NTS
DATE	08.07.10	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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